

Work Order ID 85703

85703

Page 1

June-13-12 4:05:55 PM

Item ID: D2888

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Lug

Stop *NS2*

Start Date: 13/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 27/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/14

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2888

Rev A2

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks at 4.200" long
Grain along 4.200"*

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio D2888
Folio Rev: AA
Dwg Rev: A2

2-Deburr

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

PO

12/07/24

P

Ø

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

only 12/07/26

8

Ø

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

8

MA

12-7-30

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Stop

NS2

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8

Cust Item ID:

Required Date: 27/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

170

Identify as per dwg & Stock Location: 51429

0.00

170

Packaging

Packaging

Memo

0.00

8 x

M 12/07/31

8 x 6 12/04/31

8 12/08/01 JB

M121841

9:30
320 F
10:00

| W/O: | | WORK ORDER CHANGES | | | | | |
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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/8/12

MW 12/08/10

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

June-13-12 4:05:59 PM

Page 1

Work Order ID: 85703

85703

Parent Item: D2888

D2888

Parent Item Name: Lug

Start Date: 13/06/2012

Required Date: 27/06/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP C00.06.22Removed P/O for powder coatEC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B2.500X03.50 0 | | Purchased | No | | | 100 | f | 11.0700 | 0.39 | 3.12 | | | |

M6061T6B2 500X03 500

**

6061-T6 Bar 2.50 x 3.50

Location

Loc Qty

Loc Code

MAT004

7.32

121070

7.32

MAT008

3.75

→ 120708

3.75

PO 12/07/20
3.15

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NOTE: Date & initial all entries

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|-----------------------|---------|--------------|-------|
| DART AEROSPACE LTD | | Work Order: | 85703 |
| Description: Lug | | Part Number: | D2888 |
| Inspection Dwg: D2888 | Rev: A2 | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.386 | +0.005/-0.000 | 0.388 | ✓ | | VERN | P40-01 |
| Ø0.88 | +/-0.030 | 0.875 | ✓ | | " | " |
| 0.063 x 45° | +/-0.010 | 0.060 | ✓ | | " | " |
| 4.06 | +/-0.030 | 4.064 | ✓ | | H. G. | |
| Ø0.760 | +0.005/-0.000 | 0.764 | ✓ | | VERN | P10-01 |
| 3.48 | +/-0.030 | 3.491 | ✓ | | " | " |
| 2.500 | +/-0.010 | 2.499 | ✓ | | " | " |
| 2.75 | +/-0.030 | 2.760 | ✓ | | " | " |
| 0.438 | +/-0.010 | 0.434 | ✓ | | " | " |
| 0.080 x 45° | +/-0.010 | 0.075 | ✓ | | " | " |
| 1.85 | +/-0.030 | 1.852 | ✓ | | " | " |
| 1.000 | +/-0.010 | 1.000 | ✓ | | " | " |
| 0.425 | +/-0.010 | 0.423 | ✓ | | " | " |
| 0.030 x 45° | +/-0.010 | 0.020 | ✓ | | " | " |
| 1.875 | +/-0.010 | 1.873 | ✓ | | " | " |
| 0.375 | +/-0.010 | 0.372 | ✓ | | " | " |
| R0.25 | +/-0.030 | 0.250 | ✓ | | R. G. | |
| 1.29 | +/-0.030 | 1.286 | ✓ | | VERN | P40-01 |
| 0.414 | +/-0.010 | 0.410 | ✓ | | " | " |
| 3.41 | +/-0.030 | 3.402 | ✓ | | " | " |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | | |
|-----------------|-----------------------|---------------------|-----|
| Measured by: PO | Audited by: <i>mf</i> | Prototype Approval: | N/A |
| Date: 12/07/24 | Date: 12/07/26 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|-----------------|-----------|
| A | 08.06.04 | New Issue | KJ/DD <i>af</i> | <i>DD</i> |

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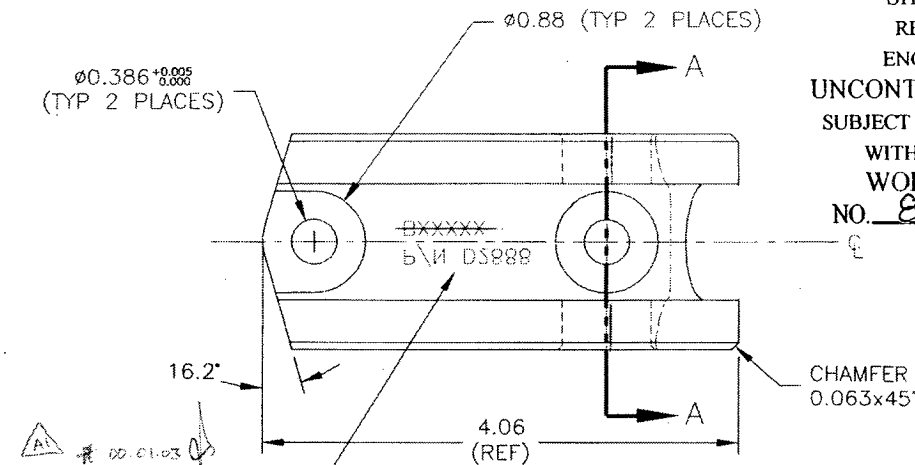
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 85703 MLJ

12/06/14



ENGRAVE DART PART
NUMBER AND BATCH
NUMBER IN THIS AREA
ON BOTTOM SURFACE

ENGRAVE DART LOGO IN
THIS AREA. 0.50" HIGH
x 0.010 DEEPLIGHTING

0.080x45°
CHAMFER

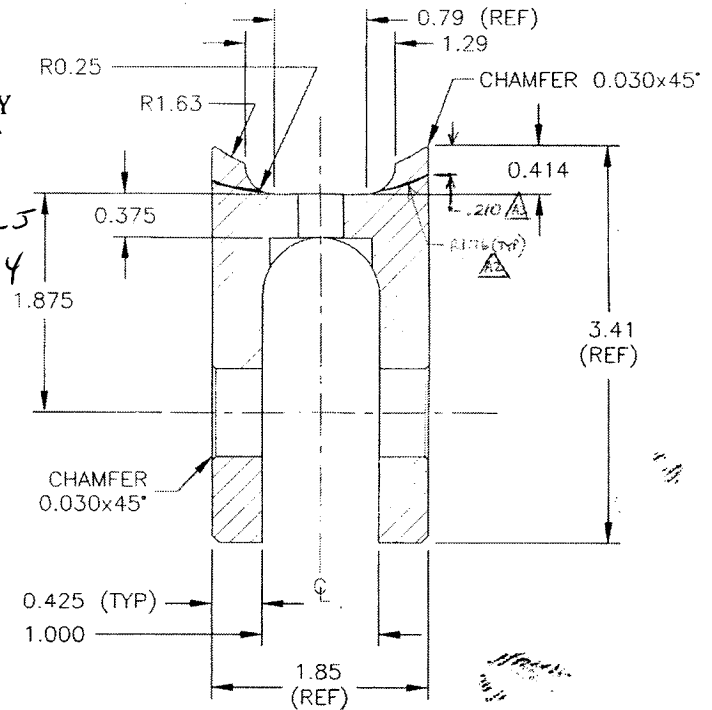
0.438

2.75

2.500

3.48

ENGRAVE P/N
(REF)



SECTION A-A
SCALE 1:1

RELEASED
91.01.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR
QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| | | |
|---------|----------|--|
| A | 99.06.21 | NEW ISSUE |
| DESIGN | DRAWN BY | DART DART AEROSPACE LTD WARRICKSBURY, OXFORD, GBR |
| CHECKED | APPROVED | DRAWING NO. D2888 |
| DATE | 99.06.21 | TITLE LUG |
| A2 | 04.04.08 | Add Saddle Clearance Per NCR 784 |
| A1 | 00.10.21 | Update Engineering |

| W/O: | | WORK ORDER CHANGES | | | | | |
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